Work	Qrder	II	63	378
Thursday	October	20	2010	10.1



Thursday, Octob	er 28, 2010 10:23:13 AM									Page I
Item ID: Revision ID:	D206-642-541		Accept				S	Setup Sta	rt	
Item Name: ,	Replacement Skidtube							Sto	р	
Start Date: Required Date: Reference:	10/28/2010 Start Qty: 1.00 11/11/2010 Req'd Qty: 1.00			Cust Item I Customer:	D:					·
Approvals:	Process Plan:	Date 10-16-28	Tooling:	Da	ite:		F	tun Sta	rt	
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Item	ID:
Revi	sion I
Item	Nam
Start	Date

D206-642-541

Accept



Setup Start

Stop



ID:

ıe: Replacement Skidtube

Required Date: 11/11/2010

e:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Date: _____

Cust Item ID: Customer:

Reference:

Ap	prova	ıls:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

110



Skidtubes Skidtubes

Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code **Qty**

Accept Reject Oty

Reject Number

Insp. Stamp

Skidtubes

Memo

0.00

**** VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg SAD 10-11-03 ©

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 10-11-04 BE 10-11-04

Date:

3- weld fwd cap as per dwg D3274 and OSI004 AR Aluminum Rod Batch: 11/13/85

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BE 10/11/04

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W/O:			W	ORK ORDER CHANGE	S	-			
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Thursday, October 28, 2010 10:23:13 AM



Page 3

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Replacement Skidtube Item Name:

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00



Cust Item ID: Customer:

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Date:_____

Date: _____

Tooling: SPC (Y/N):

Date: Date: ____ Run

Start



Stop

Sequence ID/ **Work Center ID**

120

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

HandFinish

Hand Finishing

Memo

0.00

Tool ID

130

QC

Quality Control

QC3- Inspect Part Finish

Memo

Memo

140

Quality Control

QC5- Inspect part completeness to step on W/O

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W/O:		WORK ORDER CHANGES							
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	QC:			Date:		SPC (Y/N):		Da	ite:				Stop		
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Skidtubes			Memo			0.00		,			####				
Skidtubes		:	1-Open Ø0.3	ssbolt spacer		spacer holes as per Dwg		om .	<u>.</u>		١			臣	3 iohuli
		: :	A/R□□Sika1 Sikaflex expi Start:□ /O ~	lex-291□/ re date:□//~/, 5/□Tim ////6 □Ti	er Dwg D327 			D	\mathcal{D}	/	10 -	-1/	- <i>!</i>	5	

160 QC QC

QC5- Inspect part completeness to step on W/O

0.00 2 10/16

Quality Control

Memo

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Thursday, October 28, 2010 10:23:13 AM



Page 5

Item ID:

D206-642-541

4 Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

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Process Plan:

Operation

Description

Date: ___

Tooling:

Date:

Date:

Stop

Start

Run

QC:

Date:

SPC (Y/N):

0.00

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Oty

Reject Insp. Number Stamp

Work Center ID 170

Sequence ID/

Skidtubes Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

QC5- Inspect part completeness to step on W/O

180

QC

Quality Control

Memo

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W/O:	•	,	W	ORK ORD	ER CHANC		- 3 f				
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Thursday, October 28, 2010 10:23:13 AM

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Operation

Skidtubes

Req'd Qty: 1.00 **Required Date:** 11/11/2010



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

190



Skidtubes

Skidtubes

Description

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Memo

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use

aluminum rod

A/R - Aluminum Rod - M111385

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

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Work Order ID 63378

Thursday, October 28, 2010 10:23:13 AM



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Item ID:

D206-642-541

Accept



Setup Start



Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Qty: 1.00

QC: ____ Date:



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: ____ Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

210

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept **Qty**

Reject **Qty**

Reject Insp. Number Stamp

Memo

0.000 10/11/23

220

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00 =) M 10/11/23

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

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START TIME:

0.00

0.00

0.00

1 Bf 10-11-23.

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W/O:		-	W	ORK ORDER CHANGE	S					
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Quality Control



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Sequence ID/ Work Center II 240 QC Quality Control		Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		teject lumber	Insp. Stamp		
250 HandFinish Hand Finishing		2-Install inser	ts as per Dwg D32° lex-291 □ <u>^/</u>	0.00 0.00 274. Apply LPS-3 to Nut Plate a 45 6 44. Use a drop of Sikaflex inside in 5 1 1 4 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	nd rivets.	75		(Ļ	<u> </u>				
260 		QC5- Inspect part comple	teness to step on W/	0.00				nd (/	0	11	25 (I)		

0.00

Memo

Inspect Nut Plate & Inserts

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W/O:			W	ORK ORDER CHAI	NGES	,			,	
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Thursday, October 28, 2010 10:23:13 AM



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Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00 **Required Date:** 11/11/2010

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Reference.								
Approvals:	Process Plan:	Date: Date:			R	tun Sta		
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Sequence ID/ Work Center II	Operation Description		Set Up/	Tool ID	Tool #		Accept	Reject
270	Description		Run Hours 0.00	00		Code	Qty	Qty

H 10911/2-

Reject Number Stamp

Insp.

270

HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

Memo

I-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274 A/R□□Sikaflex-291 □ ///// Sikaflex expire date:

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: \mathcal{L} \mathcal{L}

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

Sikaflex expire date:

A/R DSikaflex-291 D NULS / (D)

280

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

2014/25

Dart Ae	rospace L	td							•
W/O:			WC	ORK ORDER CHANG	SES				ı
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 63378

Required Date: 11/11/2010

Thursday, October 28, 2010 10:23:13 AM



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Item ID:

D206-642-541

Accept

Setup Start

Stop



Revision ID:

Item Name: Start Date:

Replacement Skidtube

10/28/2010

Start Oty: 1.00

Req'd Qty: 1.00

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Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

_____ Date:

Tooling:

Date: Date:

Tool # Plan

Code

Start Run

Stop

Reject

Qty

Accept

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

290

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

Quality Control

Memo

Memo

0.00

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Picklist Print

Thursday, October 28, 2010 10:23:18 AM

Work Order ID: 63378

Parent Item:

D206-642-541

Parent Item Name:

Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B□05.09.23 □ Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23

Added SS Wearplates & Gaskets JLM

IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD

IPP Rev:E

08-04-17 as per PAR 08-015 DD verified by:EC

IPP Rev:F 08-06-02 IPP Rev:G 08-10-09

add comment DD verified by:EC revise details DD verified byEC

No

No

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Manufactured

Manufactured

Manufactured

Bin Primary Item Location Last Location

Route Seq ID

110

110

150

Unit of Measure

Qty on Hand

63.0000

Qty per Kit

Total Qty

Qty Issued Date Issued

Status

D2600-1-190

Extrusion Round 3" 206

Location

59874

Loc Qty Loc Code 63 15 48

Each

Each

Each

141.0000

D3285-1

Cap

Location

LG

52511 52647 141 74 67

Loc Qty

0.0000

Loc Code

D3282-041

Float Web (206L/407)

B 633 90

Page 1

W/O:			W	ORK ORDER CHANG	GES					7
DATE	STEP	PRO	OCEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print Thursday, October 28, 2010 _, 10:23:18	AM									Page 2
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D3275-1	Manufactured	No		190	Each	216.0000	12	12		
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SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date			Chief Eng	QC Inspector
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	STEP	STEP PRODUCTION OF NC	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PROCEDURE CHANGE PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A STEP Description of NC Section A Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE PAR #: Fault Category: NCR Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC	STEP PROCEDURE CHANGE By PROCEDURE CHANGE By Fault Category: NCR: Yes N Resolution: Disposition: QA: N/C Clos WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Sign &	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Date PAR #: Fault Category: NCR: Yes No DQ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Date Qty STEP PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr Prod Mgr Prod Mgr Date: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Section C Section C Chief Eng (NCR) STEP Description of NC Section A Approval Chief Eng (NCR) STEP Description of NC Section A Section C Chief Eng (NCR)

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Picklist Print									Page
Thursday, *October 28, 2010 10:23:18	AM								T tige
Work Order ID: 63378									
Parent Item: D206-642-541		. ,							
Parent Item Name: Replacement Skidtu	ube	1 188/118 1818 118		(884)	191	s	tart Date:	10/28/2010	Required Date: 11/11/2010
							Start Qty:	1.00	Required Qty: 1.00
D3415-041	Manufactured	No		250	Each	52.0000			10/11/25
		<u>L</u>	<u>ocation</u>	<u>Lo</u>	c Oty	Loc Code			
		S	Т056		52				
	•		33842		52			<u> </u>	
CCR264SS3-3	Purchased	No		250	Each	416.0000		2	
Cherry Rivet								M	10/11/25
		L	ocation	Lo	c Oty	Loc Code			
		2	T311		416				

112314 113539

113973

Purchased

No

		74
Location	Loc Oty	Loc Code
PKG11	886	
114723	886	M116049 x 18
ST282	1728	
110511	10	
115911	1718	V 6 O
ST381	39	
114654	39	

2,653.000

44

Each

368

250

ALS4-1032-130

Insert

W/O:			WO	RK ORDER CHANC	GES				•
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							<u> </u>		
Part No	Part No: PAR #:		Fault Categ	ory:	NCR: Yes	No DQ	· · ·		
	Resolution:			·	QA: N/C Ci	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	()			
DATE	STEP	Description of NC	Description of NC Corrective				cation		Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Picklist Print Thursday, October 28, 2010 10:23	3:18 AM							Page 4
Work Order ID: 63378 Parent Item: D206-642-541								a
Parent Item Name: Replacement S.	kidtube					Start Date: Start Qty:		Required Date: 11/11/2010 Required Qty: 1.00
D3536-15 Gasket	Manufactured	No		270	Each	18.0000 1	1 <u> </u>	01112
			Location FP 56055 60875 FP11 59238	<u>Loc C</u>	6 1 5 12	<u>Loc Code</u> 13 63568		- - - -
D3536-23	Manufactured	No	62459	270	11 Each	3.0000 1	1 Il	10111175
			Location FP011 61237	Loc C	3 3	Loc Code 1363238	X (_
D3536-35	Manufactured	No		270	Each	16.0000 1	1 _yu 10	011125
			Location FP012 58683 61692 62462	<u>Loc C</u>	16 1 3 12	Loc Code 1363579	<u></u>	_ _ _
D3536-39 Gasket	Manufactured	No		270	Each	12.0000 1	1 Jel	10(11/25
Charte			<u>Location</u> FP12 58215 58571	<u>Loc C</u>	0ty 12 1	Loc Code 1363578	<u> </u>	

W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
								Prod Mgr	,					
							}							
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	s No DO	QA:	Date: _						
	R	esolution:	Disposit	ion:	_ QA: N/C	Closed: _		Date: _						
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NC	R)								
DATE	STEP	Description of NC			ion B	Veri	fication	Approval	Approval					
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Picklist Print

Thursday, October 28, 2010 10:23:18 AM

Work Order ID: 63378

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 5

Start Qty: 1.00

Required Qty: 1.00

D3535-15	

Wearshoe

Manufactured	N
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Manufactured

Manufactured

No

270

Each



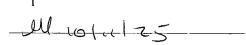
Location	Lo	oc Qty	Loc Code
FP18		22	
61241		6	
62241		3	
62707		13	
	270	Each	26.0000

D3535-35

Wearshoe

<u>_ocation</u>	Loc	· Qty	Loc Code
FP018		26	
60865		6	
62461		12	
62969		8	
	270	Each	27.0000





117		

Wearshoe

D3535-39

Location	Loc Qty	Loc Code
FP18	27	
60233	16	
62945	11	

W/O:			WC	RK ORDER CHANGE	S				
DATE STEP P			OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	:	Date:	
	R	esolution:	Disposition	n:	QA: N/C Cld	osed:		Date:	
NCR:		\	WORK ORD	R NON-CONFORMA	NCE (NCR)			
DATE	CTED	Description of NC		Corrective Action Section	VARITIC		cation Approval	Approval	
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Thursday, October 28, 2010 10:23:18 AM							r age o
Work Order ID: 63378							
Parent Item: D206-642-541							9
Parent Item Name: Replacement Skidtube				•	Start Dat Start Qt	e: 10/28/2010 y: 1.00	Required Date: 11/11/2010 Required Qty: 1.00
D3535-23 Manufactured Wearshoe	No		270	Each	28.0000	1 1 <u>I</u>	olutz
		<u>Location</u>	Lo	<u>Oty</u>	Loc Code		
		FP		7			_
		61830		6			_
		FP021 60231		21 8			_
		62706		13		× (and the state of t
D3537-3 Manufactured	No		270	Each	40.0000	1 1	
						ell 1	011175
		<u>Location</u>	Lo	e Oty	Loc Code		
		FP17		40	1362926	X	_
		60866 61674		3 17			_
		62705 <u>.</u>		20		-	_
D3537-1 Manufactured	No		270	Each		9 9	-
Wearpad						<u> </u>	10/11/25
		Location	<u>Lo</u>	e Oty	Loc Code		
		FP SEACE		1	12 12978	y.4	

Location	Į.	Loc Qty	Loc Code	
FP		1	- 4 5	<u></u>
	55465	1	1362978	
FP017		59		
	61986	15		
	62209	44		
FP17		6		
	57713	3		
	60491	3		

W/O:			W	ORK ORDER CHANG	GES					_
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Y	es No	DQA	۸:	Date: _	
Resolution: Disposition:				on:	QA: N/C	Clos	ed:		Date: _	
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Thursday, October 28, 2010 10:23:18 AM

Work Order ID: 63378

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Oty: 1.00

AN960C10L

Parent Item:

NAS1149C0332

Purchased

No

270

270

270

Each

29.0000

80 80

washer

AN960C416

NAS1149C0463

Purchased

No

ST245

Location

107534

Loc Oty 29

29

Each

M 115832

30.0000

Loc Code

washer

D3672-1

Manufactured No Location ST346

100993

52505

Loc Qty 30

Loc Code M 115358

30 Each

697

847.0000

10/11/25

x80 40 1014/20

Phenolic Washer

Location Loc Qty ST077 42329

847 150 Loc Code

W/O:			W	ORK ORDER CHANGI	ES	*******		*
DATE	STEP	PRO	PROCEDURE CHANGE			Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:_	Date: _	
	Resolution: Disposition:				QA: N/C Clo	sed:	Date: _	
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DATE	STEP	Description of NC	Description of NC Corrective Action			Verificati	on Approval	Approval
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Picklist Print Thursday, October 28, 2010 10:23:18 AM							Page 8
Work Order ID: 63378 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube			18) 18)		Start Date Start Qty	: 10/28/2010	Required Date: 11/11/2010 Required Qty: 1.00
AN3C4A Pu	urchased P	No	270	Each	2,233.000 80		
		ST350 114 114 114 115 115	5438 4108 4416 4523 5300 5589	3 3 2230 14 12 2 202 1000 1000	<u>Loc Code</u>		
AN4C5A Pu	rchased ¹		270 <u>L</u> 0552 2243	Each oc Qtv 481 4 477	481.0000 1		Dlul Z
D2646 M Aft Cap	anufactured 1	No	270	Each	45.0000 1	1	10/1/25
		<u>Location</u> FP-4	_	35 35	Loc Code 12 (03 (03 7		

Locatio	<u>n</u>	Loc Oty	Loc Code	
FP-4		35		
	57332	35	B63633	
fp5		6	() @) @ 3 3	
	62652	6		
FP6		4		
	52663	4		

Dark Acrospace Eta											
W/O:			WORK ORDER CHANGES						, 3		
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval* Chief Eng / Prod Mgr	Approval QC Inspector	
		·									
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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Thursday, October 28, 2010 10:23:18 AM

Work Order ID: 63378

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 9

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Ring

Manufactured

270

Each

23.0000

Location	Loc Oty	Loc Code	
ST473	23		
51586	1		
53446	7		
61322	15		χ (

W/O:			WO	RK ORDER CHANGI	ES			1	•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	: 	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A :	_ Date: _	
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NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	OTED	Description of NC			on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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DESIG	CP	DRAWN BY	DART AEROSPACE USA, INC.
CHECK	KED A	APPROVED 4	DRAWING NO. REV. D
	#	 	D3274 SHEET 1 OF 4
DATE			TITLE SCALE
06.1	2.19		SKIDTUBE ASSEMBLY NTS
Α		04.03.15	NEW ISSUE
В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
ပ		05.03.16	ADD -043; NEW INSERTS
D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

Otto	One	1	
Qty -041	-043	Part Number	Description
X	-043		SKIDTUBE ASSEMBLY
<u></u>	 	D3274-041	
 	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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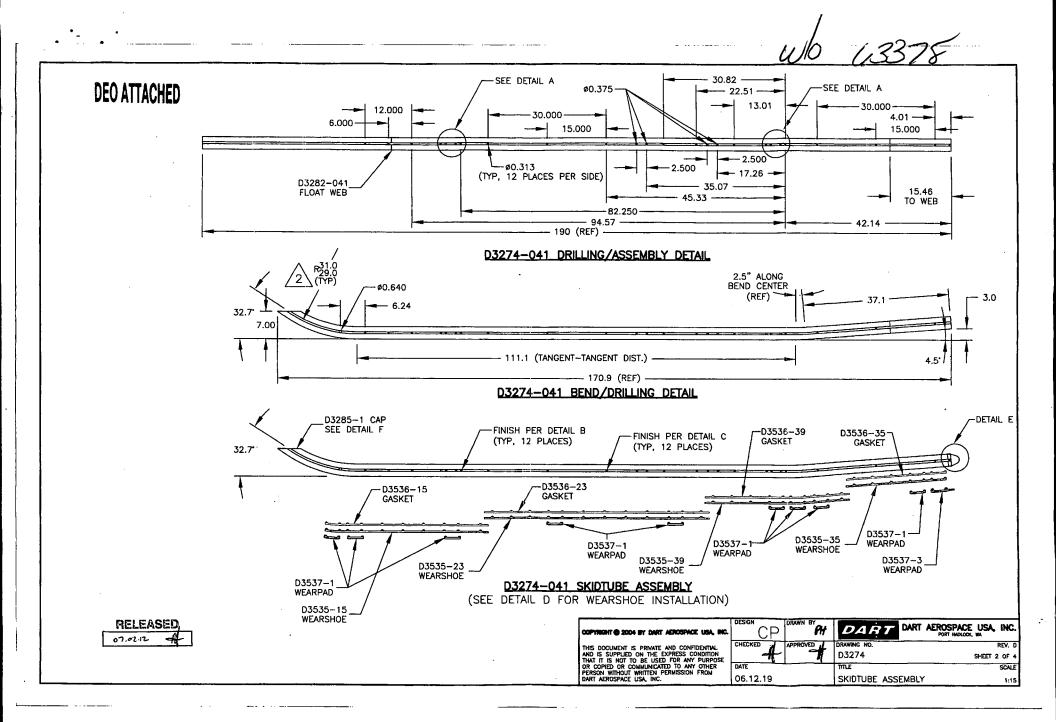
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UNCONTROLLED COP SUBJECT TO AMENDMEN

SHOPCORY RETURN TO ENGINEERING

MITHOUT NOTICE WORK QRDER

W/O:			V	VORK ORDER CHA	NGES					
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Part No	;	PAR #:	_ Fault Ca	tegory:	NCF	R: Yes I	No DQA:		_ Date: _	
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DATE	STEP	Description of NC		Corrective Action	Section B	01 0	Verificati	ion	Approval	Approval
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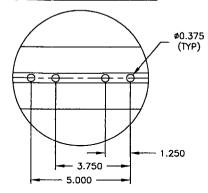


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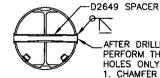
30.82 SEE DETAIL A 1.500 (TYP) -SEE DETAIL A Ø0.375-22.51 DEO ATTACHED 30,000 13.01 15.000 --- 3.000 PITCH 4.01 3.000 PITCH--1.500 (TYP) 3.000 PITCH------ 2.500` 1.500 Ø0.313 (TYP) (TYP, 37 PLACES PER SIDE) D3282-041 FLOAT WEB - 35.07 15.46 45.33 TO WEB -82.250-91.57 42.14 190 (REF) D3274-043 DRILLING/ASSEMBLY DETAIL 2.5" ALONG BEND CENTER Ø0.640 (REF) - 3.0 32.7 - 111.1 (TANGENT-TANGENT DIST.) - 170.9 (REF) D3274-043 BEND/DRILLING DETAIL D3285-1 CAP -DETAIL E SEE DETAIL F FINISH PER DETAIL B D3536-35 FINISH PER DETAIL C D3536-39-(TYP, 12 PLACES) **GASKET** (TYP, 37 PLACES) **GASKET** 32.7 -D3536-23 GASKET D3536-15 GASKET D3537-1 D3535-35 D3537--1 WEARPAD D3537-1 WEARSHOE WEARPAD WEARPAD D3535-39 WEARSHOE D3537-3 WEARPAD D3535-23 WEARSHOE D3537-1 WEARPAD D3274-043 SKIDTUBE ASSEMBLY (SEE DETAIL D FOR WEARSHOE INSTALLATION) D3535-15 RELEASED WEARSHOE DART AEROSPACE USA, INC. PH DART THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. D3274 SHEET 3 OF DATE SCALE 06.12.19 SKIDTUBE ASSEMBLY 1:15

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W/O:			WC	ORK ORDER CHANG	SES									
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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NCR:			WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC Section A	Initial	Action Description	tion B	Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector				
			Chief Eng	Chief Eng		Date								
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DETAIL A: DRILL DETAIL



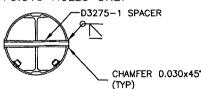
DETAIL B FOR Ø0.375 HOLES ONLY



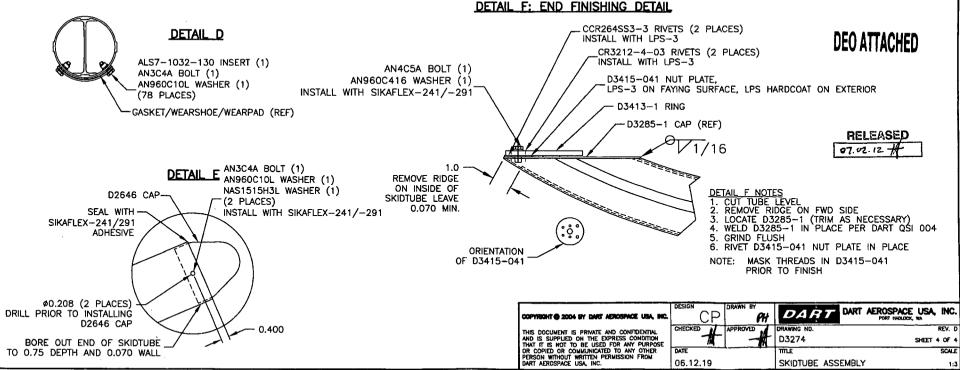
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.375 HOLES ONLY:

- 1 CHAMFER HOLF 0.030x45"
- 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO 00.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY



DETAIL F: END FINISHING DETAIL



W/O:			WO	RK ORDER CHANGE	S		 	*	. •
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DRAWING		TITLE	1	REV. D D	ART AEROS	SPACE USA, II	IC D.E.O. NO.		SHEET NO.	SCALE
D3274		SKIDTUBE AS	SEMBLY		ENGINEE	RING ORDER	D3274-D-	1 /)	SHEET 1 OF 1	NTS
DRAWN	S	C	HECKED	4	MFG. APPR.	<u> </u>	APPROVED	NAP.	DE APPR.	
DATE	09.06.	17 D	ATE 09.06.	23	DATE 59/	c /23	DATE	09/06/23	DATE 09 06.23	

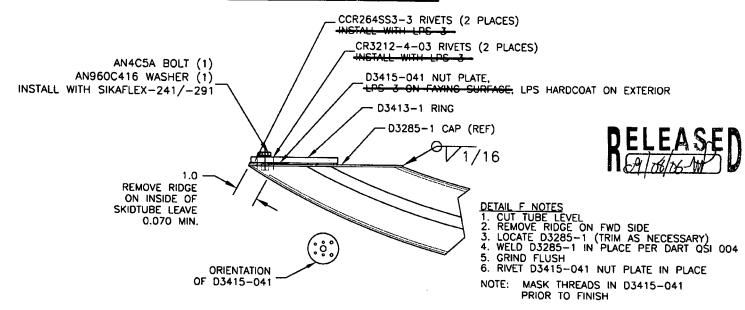
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS:

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



W/O:		WORK ORDER	CHANGES			e
DATE	STEP	PROCEDURE CHANGE	Ву	Date (Appro Chief E	ng / Approvar
J.						
*						
		in the same of the				
Part No):	PAR #: Fault Category:	NCR: Yes N	lo DOA:	Dat	e.

Disposition: _____ QA: N/C Closed: _____

Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector				
<i>*</i>								•				
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NOTE: Date & initial all entries

Resolution:

NO. 241	
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott		
	·	
Job number: <u>しみみさし</u> を		
Part number: DROW (42.541		
Description: 206 5kg		
Welding Process: Tig Mig[]		•
Base materiel: Aluminia	. •	
Current: AC[] DC[]		

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Down	Date of Test Coupon 10.0930

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.